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Indian Standard

THRUST-PADS (FIXTURES)—SPECIFICATION

(First Revision)

भारतीय मानक

थुस्ट पेंड (फिक्सचर्ज) — विशिष्टि (पहला पुनरीक्षण)

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BUREAU OF INDIAN STANDARDS MANAK BHAVAN, 9 BAHADUR SHAH ZAFAR MARG NEW DELHI 110 002 Machine Tools, Machine Tool Elements and Wood Working Machines Sectional Committee, EDC 11

FOREWORD

This Indian Standard (First Revision) was adopted by the Bureau of Indian Standards on 5 January 1989, after the draft finalized by the Machine Tools, Machine Tool Elements and Wood Working Machines Sectional Committee had been approved by the Mechanical Engineering Division Council.

This standard was first published in 1971. The committee responsible for the formulation of this standard decided to revise the same based on experience over the years. In the present revision, another type of thrust-pad (fixtures), suitable for using with snap ring has been included which is found more economical in production and assembly and hence preferred over the pin type.

In the preparation of this standard, considerable assistance has been derived from DIN 6311-1968 'Thrust pad (fixtures)', issued by the Deutsches Institut Für Normung (DIN).

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THRUST-PADS (FIXTURES)—SPECIFICATION

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1 SCOPE

This standard specifies dimensions and requirements for thrust-pads used with the screws according to IS 6336: 1989 'Specification for screws for thrust-pads (fixtures) (first revision)' or IS 12582: 1989 'Tommy screw with fixed bar — Specification'.

2 REFERENCE

The Indian Standard IS 2393: 1980 'Specification for cylindrical pins (second revision)' is a necessary adjunct to this standard.

3 TYPES

- a) Type A, thrust-pad using ring, and
- b) Type B, thrust-pad using cylindrical pin.

4 DIMENSIONS

The dimensions shall be as given in Table 1.

5 MATERIAL

Steel having minimum tensile strength of 600 MPa shall be used.

6 HARDNESS

Clamping and thrust surfaces shall be hardened to 55 HRC, Min.

7 FINISH

Thrust-pads shall be free from cracks, burrs, pits and other defects.

8 DESIGNATION

A thrust-pad, Type A, having $d_1 = 20$ mm shall be designated as:

Thrust-Pad-A20 IS 6337

9 PRESERVATION AND PACKING

- 9.1 A suitable anticorrosive surface treatment shall be given to the thrust-pads.
- 9.2 The thrust-pads shall be packed in accordance with the best trade practices.

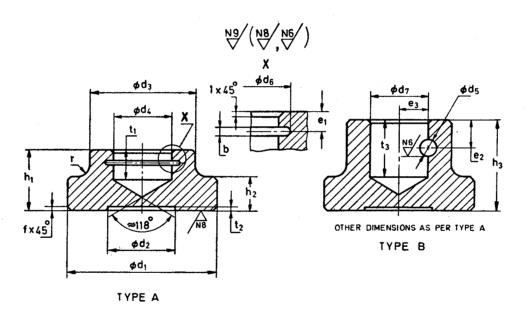
10 MARKING

Thrust-pads shall be marked at an appropriate place with the manufacturer's name, initials or trademark.

Table 1 Dimensions for Thrust-Pads (Fixtures)

(Clause 4)

All dimensions in millimetres.



12

	d_1	d_2	d ₃	<i>d</i> ₄ H12	d ₅ H7	d ₆ +0.2	d_{7}	e_1	e ₂	e_3	f	h ₁	h ₃	h ₃	r	<i>t</i> ₁	t 2	t ₃	b	Size of Corresponding		
	· 177.000 Shakes					0														Snap Ring IS 12525	Cylindrical Pin IS 2393	Screw IS 6336
-	12	5	10	4.6	1.2	5.6	4.8	1.8	2.5	2.4	0.6	7	2.5	8	1.2	4	0.2	5	0.7	4.5	1·5 m 6×8	M6
	16	7	12	6.1	2	7:7	6.4	2	3	3.5	0.6	9	4	9.5	2	5	0.2	6	1 -	6.0	2.0 m 6×8	M8
	20	8	15	8.1	2	9.7	7.4	2	3.2	3.7	0.6	11	5	12	2	6	0.2	7	1	8.0	2.0 m 6×12	M10
	25	10	18	8.1	3	9.7	9.5	3	4.2	4.75	1.0	13	6	15	2	7	0.2	9	1	8.0	3.0 m 6×14	M12
,	32	14	22	12.1	3	14'2	12.2	3.2	6.0	6.52	1.0	15	7	19	3	7.5	0.7	12	1.5	12.0	3.0 m 6×16	M16
	40	18	28	15.6	4	19.8	15.5	3.2	7:5	7.75	1.0	16	9	24	3	8	1.0	15	1.8	15.5	4.0 m 6×20	M20

NOTE — Dimensional deviations for untoleranced dimensions: Medium class according to IS 2102 (Part 1): 1980 'General tolerances for dimensions and form and position: Part 1 General tolerances for linear and angular dimensions (second revision)'.

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